

Work Order ID 71314

Page 1

Tuesday, June 28, 2011 9:58:49 AM

Item ID: D3391-023

Accept



Setup Start



Revision ID:

Item Name: Mid Tube Assembly

Stop



Start Date: 6/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF.Date: 11-06-28

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	Rev H	0.00							
100	Skidtubes	0.00							



Skidtubes

Memo

0.00

1-Cut tube to finish length as per Dwg D3391

2-Identify as D3391-023

3-Drill pilot holes using DT8796 (Do not drill "B" holes) and drill only 1 fwd saddle hole on one side only as per Dwg D3391

4-Open saddles and GHW holes to Ø0.375" except for fwd saddle hole of detail "J"

5-Remove .030" from Fwd indexing Ridge as per Dwg D3391

6-Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391

7-Deburr

8-Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.250" holes with paint marker,

9-Open wearplate holes of D3391-023 assembly detail section G-G to Ø0.250" (14 holes) as per Dwg D3391 and 2 holes in section Detail "J", do not open wearplate holes of section "J"

10-Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.297" (20 holes) as per Dwg D3391

SCRAP

PW →

11-6-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3391-023 PAR #: N/A Fault Category: Landing Gear NCR: Yes No DQA: ✓ Date: 11.07.04
 11-1695 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ✓ Date: 11/07/05

NCR: 7314		WORK ORDER NON-CONFORMANCE (NCR) #1140.5						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/06/05	# 100.9	Operator uses wrong drill bit to open up wear point holes. He picked a #500" drill bit. Should of used #0.2921	✓ O/S/05	Scrap + Destroy mis tube (O/S+) No Penetr	✓ 11/06/05	S 11/06/05	✓ O/S/05	S 11/06/05
		R.C. operator error / Lack of Attention						

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 71314

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Tuesday, June 28, 2011 9:58:49 AM

Item ID:	D3391-023	Accept		Setup	Start		
Revision ID:						Stop	
Item Name:	Mid Tube Assembly						
Start Date:	6/28/2011	Start Qty: 1.00		Cust Item ID:			
Required Date:	7/28/2011	Req'd Qty: 1.00		Customer:			
Reference:							
Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Stop		

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 	QC5- Inspect part completeness to step on W/O QC Quality Control	0.00							
120 	Chemical Conversion Coat per QSI005 4.1 HandFinish Hand Finishing	0.00							
130 	QC3- Inspect Part Finish QC Quality Control	0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71314

A standard linear barcode is located at the bottom of the page, consisting of vertical black bars of varying widths on a white background.

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Tuesday, June 28, 2011 9:58:49 AM

Item ID: D3391-023

Accepted



Setup Start

Stop



Revision ID:

Start Date: 6/28/2011 **Start Qty:** 1.00



Cust Item ID:

Required Date: 7/28/2011 **Req'd Qty:** 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: _____ **Tooling:** _____

Date:

Run Start

Stop



QC:

Date: _____ **SPC (Y/N):** _____

Date:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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Start Date: 6/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: _____
OVEN TEMPERATURE: _____
FINISH TIME: _____

200

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 71314

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Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210



Skidtubes

0.00

Skidtubes

Memo

0.00

Skidtubes

1- insert D3391-021 into D3391-23

2- insert T-pins into first and third fwd saddle holes

3- ON FIRST SIDE ONLY drill out 2nd and forth fwd saddles holes to 0.500" as per DSI 9364

4- remove T-pins and locate DT9415 from first and third crossbolt hole using T-pins and clekos

5- ON 2ND SIDE ONLY ream out 2nd and forth saddle hole to 0.499". Remove DT9415

6- deburr, re-alodine and blow out chips

7- press fit D3591-1 spacers using DT9416 starting from 0.500" side

220



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
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Tuesday, June 28, 2011 9:58:49 AM

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Item Name:	Mid Tube Assembly								
Start Date:	6/28/2011	Start Qty:	1.00		Cust Item ID:				
Required Date:	7/28/2011	Req'd Qty:	1.00		Customer:				
Reference:							Run	Start	
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start			
	QC:	Date:	SPC (Y/N):	Date:	Stop	Stop			

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							

Quality Control

MF 11-06-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Page 1

Tuesday, June 28, 2011 9:58:46 AM

Work Order ID: 71314



Parent Item: D3391-023



Parent Item Name: Mid Tube Assembly

Start Date: 6/28/2011

Required Date: 7/28/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A□05.10.20□New Issue□ KJ/EC□

IPP B□06.02.10□ECN773 dwg rev.D EC□

IPP C 07.03.20 rev F dwg

IPP D 07.03.28 re-format EC

IPP E 07.10.31 ecn 1053P

JPP Rev:F ECN 1056 07-11-13 DD veri

IPP Rev:F ECN 1036 07-11-13 DD verified by: EC
IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by: EC

IPP Rev:G 08-09-08 new process (ech 08-510) DD Verified by:EC
IPP Rev:H 08-09-10 revH as per dwg. DD verified by:EC

IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC
IPP Rev:J 08-11-13 Removed steps per w/o OC KL verified

IPP Rev: 1 08-11-13 Removed steps per w/o, QC KJ verified by: ec IPP Rev: 1 add in sec 140 during date: 8/1/17 verified by EC

Rev:J add in seq 140 expire date &# sikaflex DD 10.02.17 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-1-100 		Manufactured	No			100	Each	82.0000	1	1			W where
Skidtube Extrusion							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
				HALL 37065 50251			82				1		
							7						
							75						
D3391-021 		Manufactured	No			100	Each	0.0000	1	1			
Fwd Tube Assembly													
D3389-1 		Manufactured	No			140	Each	0.0000	1	1			
Web													
D3681-1 		Manufactured	No			160	Each	24.0000	5	5			
Spacer							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
				LG 68958 69893			24						
							2						
							22						

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Tuesday, June 28, 2011 9:58:46 AM

Work Order ID: 71314



Parent Item: D3391-023



Parent Item Name: Mid Tube Assembly

Start Date: 6/28/2011

Required Date: 7/28/2011

Start Qty: 1.00

Required Qty: 1.00

D3591-1

Manufactured No

210

Each

27.0000

2

2



Bushing

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST068	27	
57350	2	
66147	25	

ALS4-1032-130

Purchased No

230

Each

1,122.000

20

20



Insert

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST281	8	
117331	8	
ST282	1114	
117717	1114	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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